

Work Order ID 58787

Tuesday, May 18, 2010 3:43:30 PM



Page 1

Item ID: D3911-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Eyebolt Receiver

Start Date: 5/19/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 5/25/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 10-5-18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3911	C

100

0.00



Bandsaw

Memo

0.00

mf 10/05/19

8

0

Jeaspa Bandsaw

Cut blank to 2.885" long

110

0.00



HAAS 1

Memo

0.00

mf 10/05/23

8

0

HAAS CNC vertical machine #1

1-MILL as per folio FA917 & dwg,

FOLIO REV: AA

DWG REV: C

2-Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

OK 10/05/23

8

0

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

G.A 10/05/24

8

0

140

Identify as per dwg & Stock Location: 95

0.00



Packaging

Memo

0.00

Packaging

10-5-25 SF 82

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/26
CL1015/26

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 18, 2010 3:43:30 PM

Page 1

Work Order ID: 58787



Parent Item: D3911-3



Parent Item Name: Aft Eyebolt Receiver

Start Date: 5/19/2010

Required Date: 5/25/2010

Comments: IPP RevA: New issue DD verified by:EC
AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP REV:B

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M303B2.000X1.750		Purchased	No			100	f	2.7757	0.26			
303 BAR 2" X 1.750"												

Location

Loc Qty

Loc Code

MAT53

2.7757

113310

2.7757

2.619 on 10/6/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 58787
Description: AFT EYEBOLT RECEIVER		Part Number: D3911-3
Inspection Dwg: D3911	Rev: C	Page 1 of 1

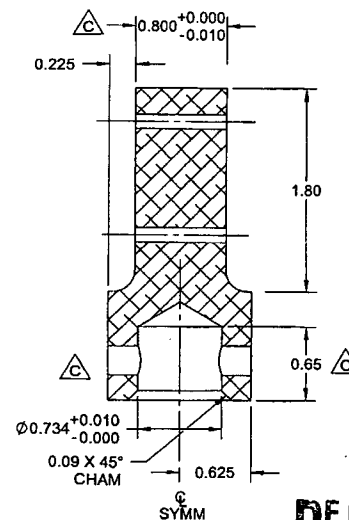
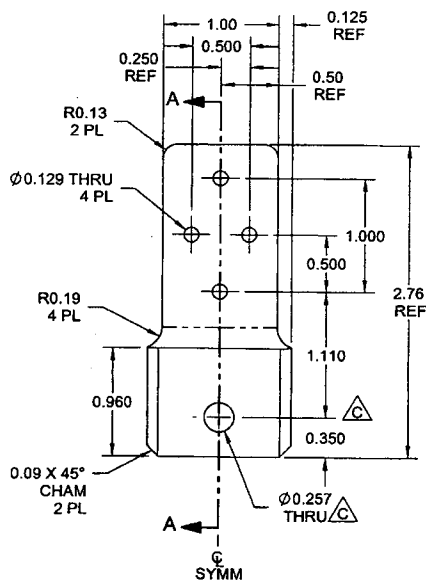
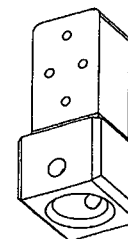
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.250	$\pm .010$	1.257	—			
1.250	$\pm .010$	1.244	—			
.09 X 45°	$\pm .030 \times \frac{1}{2}$.090 X 45°	—			
.960	$\pm .010$.964	—			
R.19	$\pm .030$	R.170	—			
Ø.129	$\pm .005$ $\pm .001$	Ø.131	—			
R.13	$\pm .030$	R.125	—			
1.00	$\pm .030$	1.000	—			
.500	$\pm .010$.500	—			
1.000	$\pm .010$	1.000	—			
.500	$\pm .010$.500	—			
1.110	$\pm .010$	1.110	—			
.350	$\pm .010$.350	—			
Ø.257	$\pm .006$ $\pm .001$	Ø.258	—			
.225	$\pm .010$.225	—			
.800	$\pm .000$ $\pm .010$.793	—			
1.80	$\pm .030$	1.797	—			
.65	$\pm .030$.654	—			
.625	$\pm .010$.624	—			
.09 X 45°	$\pm .030 \times \pm \frac{1}{2}$.090 X 45°	—			
Ø.734	$\pm .010$ $\pm .000$	Ø.736	—			

Measured by: <i>mf</i>	Audited by: <i>J.A</i>	Prototype Approval:	N/A
Date: 10/05/23	Date: 10/05/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



RELEASED
2010-06-14

SECTION A-A

NOTES:

- 1) MATERIAL -1: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
-3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -1: 0.36 lbs
-3: 0.73 lbs

D3911-3 AFT EYEBOLT RECEIVER

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3911 TITLE AFT HARDPOINT, BASKET COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ANY UNAUTHORIZED CIRCULATION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIES OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. 0
DRAWN	JPH		SHEET 2 OF 3
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		SCALE
DE APPR.	<i>[Signature]</i>		NTS
DATE	10.04.06		

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